

Work Order ID 56886



Page 1

March 12, 2010 10:05:09 AM

Item ID: D3705-043

Accept



Setup Start



Revision ID:

Item Name: Instrument Panel Weldment

Stop



Start Date: 3/12/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/22/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

*PL*Date: *10-3-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3705 Rev C

100



Large Fab

0.00

ER 10-4-5 X5

Large Fab

Memo

0.00

Large Fab

I-Assemble and weld as per dwg D3705 per QSI004|*****nice weld all
around and buff weld smooth as indicate on dwg****| Aluminum rod
batch: *M 111385*

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

⑥ PD 10.04.08

QC

Memo

0.00

Quality Control

120



QC5- Inspect part completeness to step on W/O

0.00

S10104108

QC

Memo

0.00

Quality Control

(+5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 3/22/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



HandFinish

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

BK 10-4-8 5 9

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

10-04-08

5 9

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M105642

Memo

0.00

START TIME: 10:15 AM OVEN TEMPERATURE:
10:45 AM FINISH TIME: 320°C

=> M 10 10 4 09 X5 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56886



Page 3

March 12, 2010 10:05:10 AM

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Stop



Start Date: 3/12/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/22/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

10-11-12

Draw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: BSL 884

0.00

SB 10/04/12

(5)

180



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/13 HJ

10-11-13
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

March 12, 2010 10:05:09 AM

Work Order ID: 56886



Parent Item: D3705-043



Parent Item Name: Instrument Panel Weldment

Start Date: 3/12/10

Required Date: 3/22/10

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec

Start Qty: 5.00

Required Qty: 5.00

IPP Rev:B 09-01-09 rev.C as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3705-1		Manufactured	No				Each	0.0000	5.0000			

MAIN PANEL

D3705-3



COVER PLATE

Manufactured

No

55048 x 5

Each

6.0000

5.0000

EL 10-4-5

EL 10-4-5

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

st175

Loc Qty

6

5

55049

6

D3706-1



Lock Bracket

Manufactured

No

st175	6	
55049	6	

Each

3.0000

5.0000

EL

10-4-5

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST084

Loc Qty

3

3

55050

3

D3706-3



Guide

Manufactured

No

ST084	3	
55050	3	

Each

4.0000

5.0000

EL

10-4-5

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST084

Loc Qty

4

4

55051

4

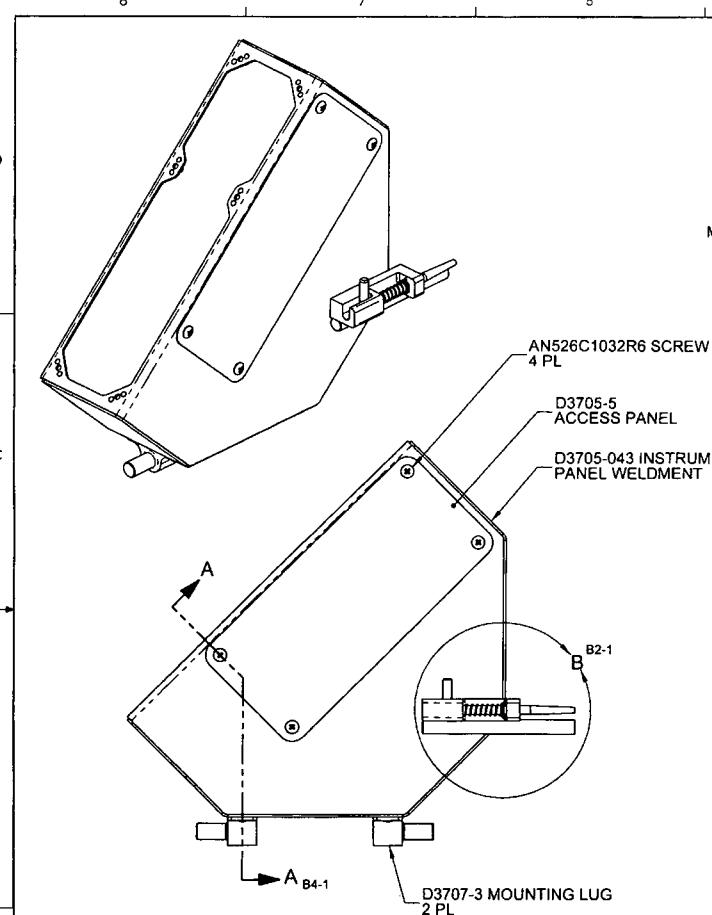
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

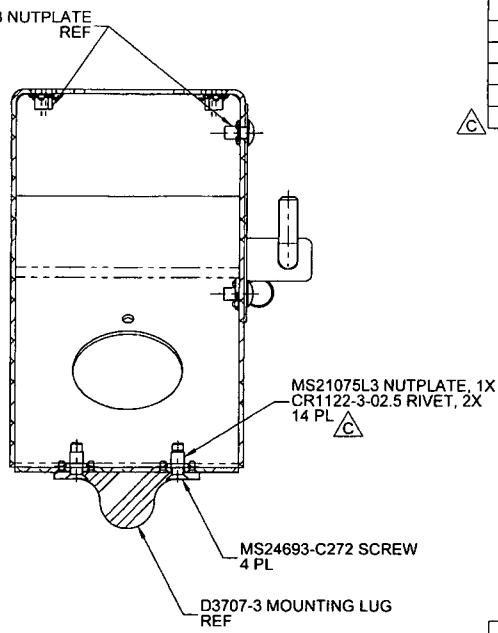
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3705-041 INSTRUMENT PANEL ASS'Y

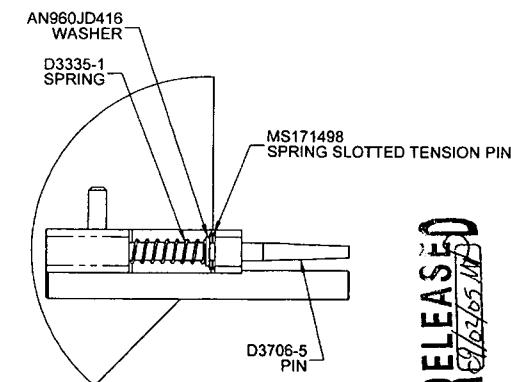
D3705-041 NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING VIN
7) WEIGHT: 2.97 lbs



SECTION A-A B7-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

ITEM	QTY	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASSY
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



DETAIL B B6
SCALE 2X

C	ADDED D3705-7/-9/-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3); Ø 1.80 WAS 1.50 (ZN D5-4). ADDED Ø 0.204 HOLE (ZN D5-4). CH117-02-02 WAS MS20426A03-D3. REASON: COMPACTED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS	MB	08.11.20
B	ADDED MS35498-156; QTY 14 MS210753 WAS QTY 8; Ø 0.223 MS35498-156 WAS QTY 16. MB140200-156 TP-2; AN526C103265 WAS MS27039-1-09 & AN960J10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1a</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>1b</i>		
CHECKED	<i>AS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DS</i>	D3705	SHEET 1 OF 6
APPROVED	<i>ND</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	INSTRUMENT PANEL ASSY	
DATE	08.11.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NO. 56864 3
BD-0-3-12

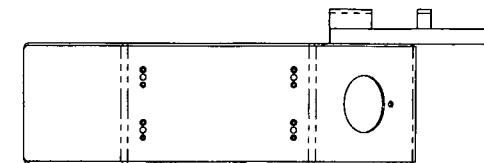
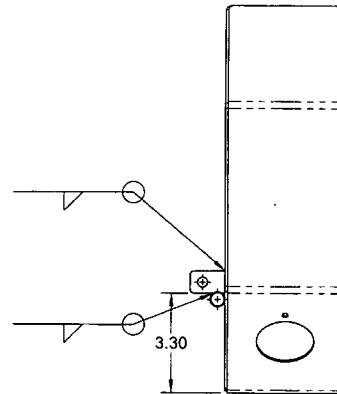
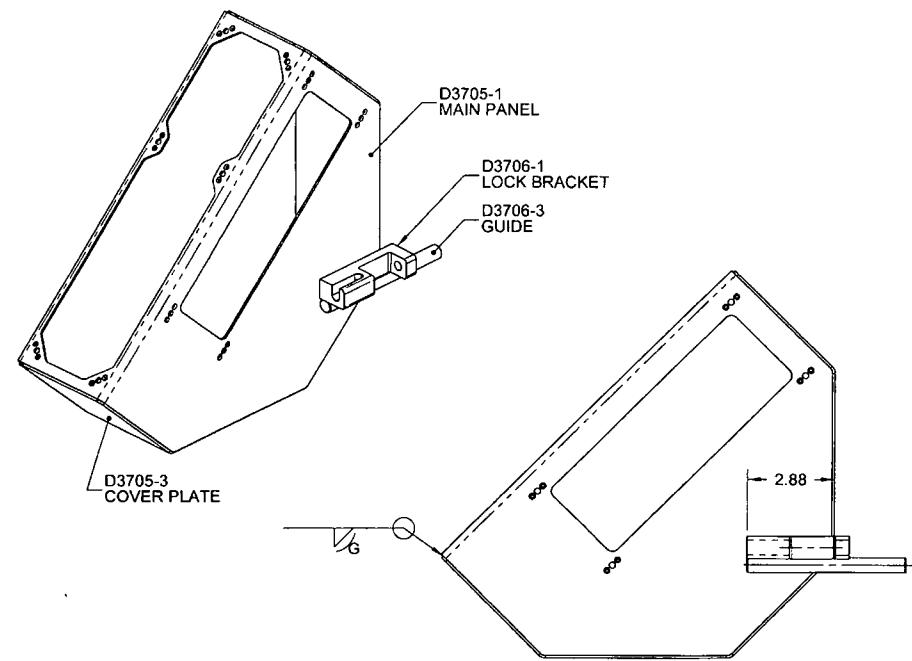
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3705-043 INSTRUMENT PANEL WELDMENT

W/0 56886

RELEASED
6/10/2015 MHD

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. C	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D3705 SHEET 2 OF 6	
APPROVED	<i>[Signature]</i>	TITLE INSTRUMENT PANEL ASS'Y NTS	
DE APPR.	<i>[Signature]</i>	DATE 08.11.20	

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A

D

C

B

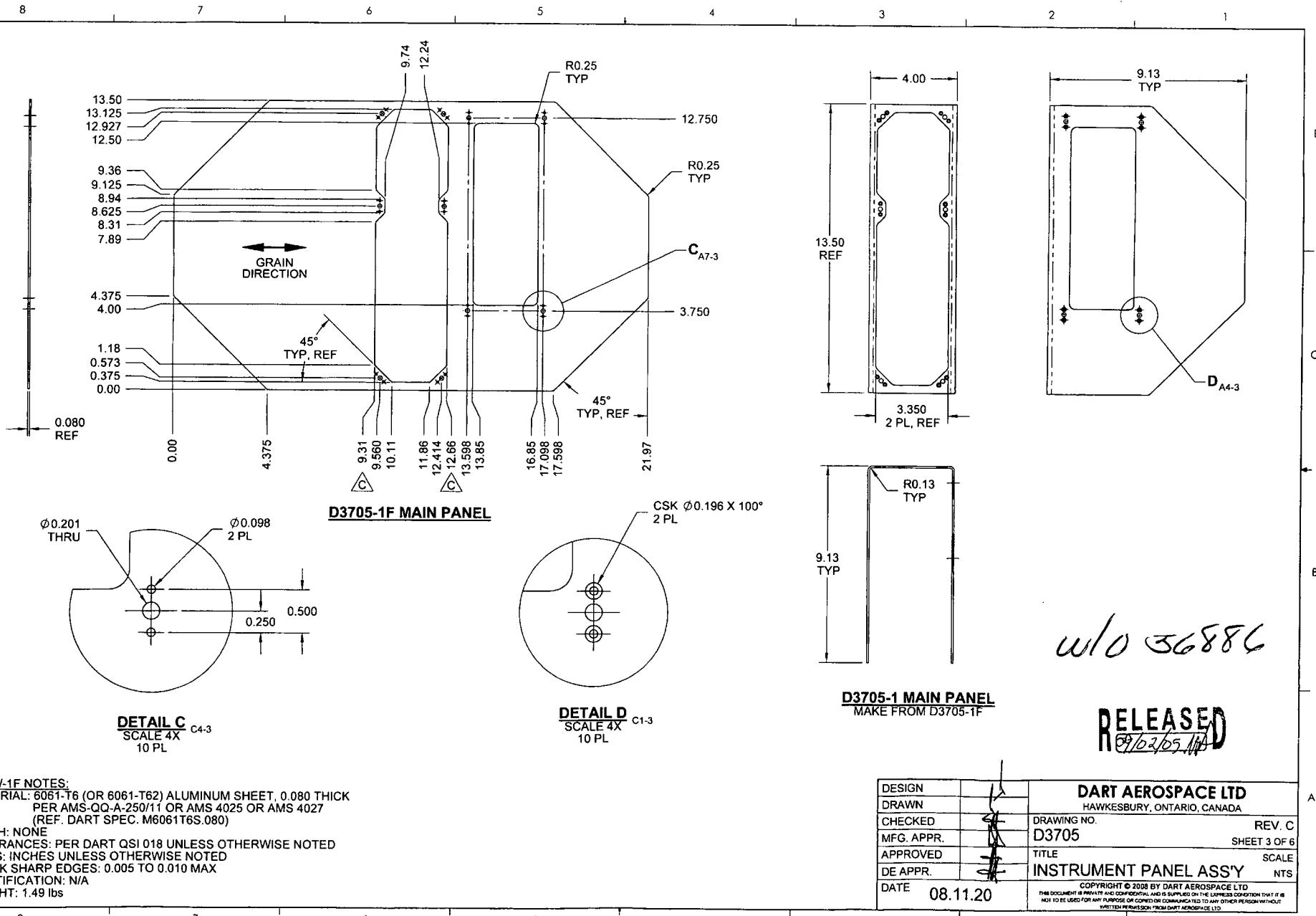
A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

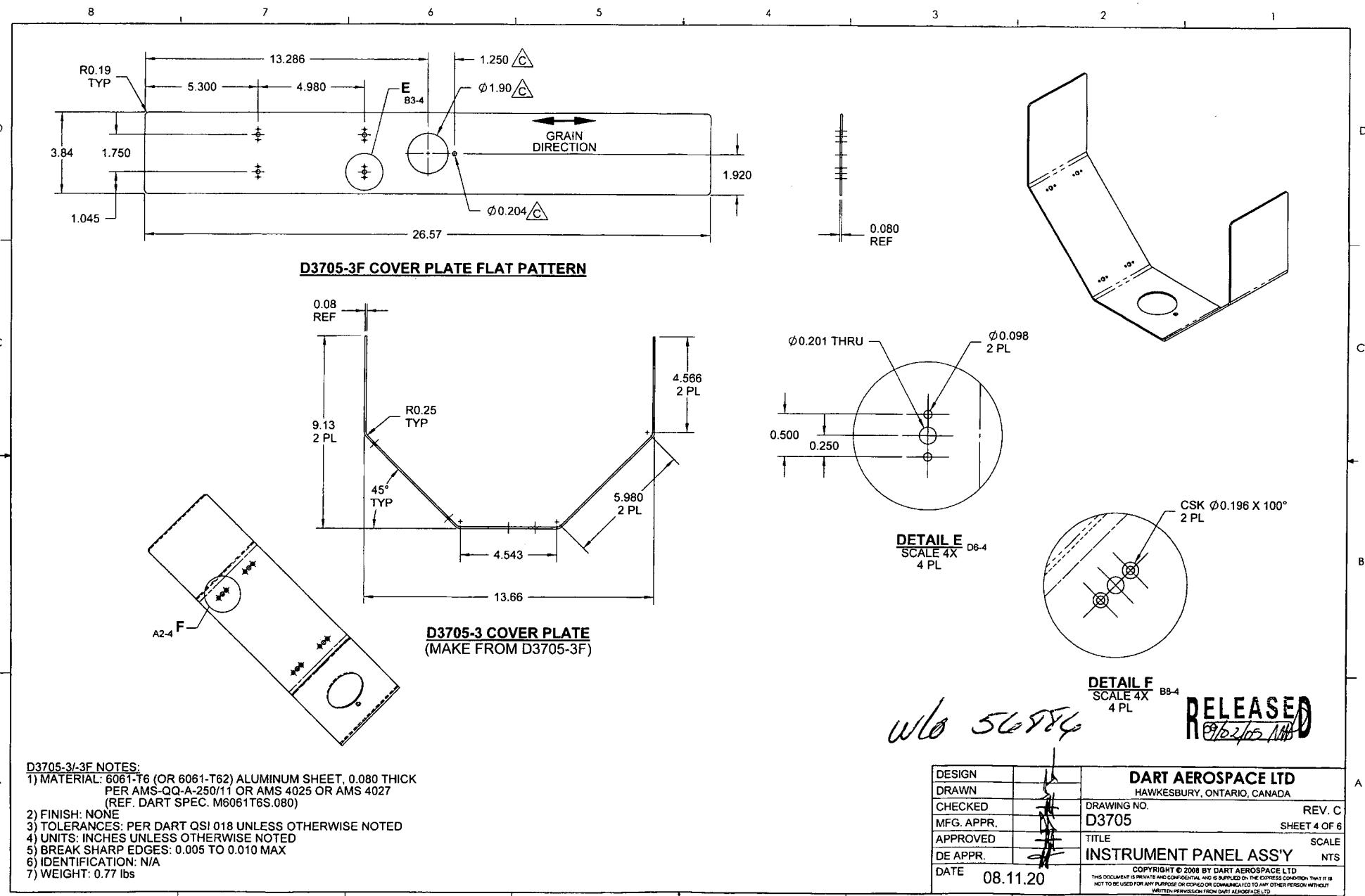


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3705-3/-3F NOTES:

507605-5/J NOTES

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.77 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD		
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	D3705	SHEET 4 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	INSTRUMENT PANEL ASS'Y	NTS	
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RELEASED
08/21/05 MHD

DETAIL F
SCALE 4X
4 PL BB

RELEASED
09/02/05 MM

RELEASED
09/02/05 MM

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HAWKESBURY, ONTARIO, CANADA

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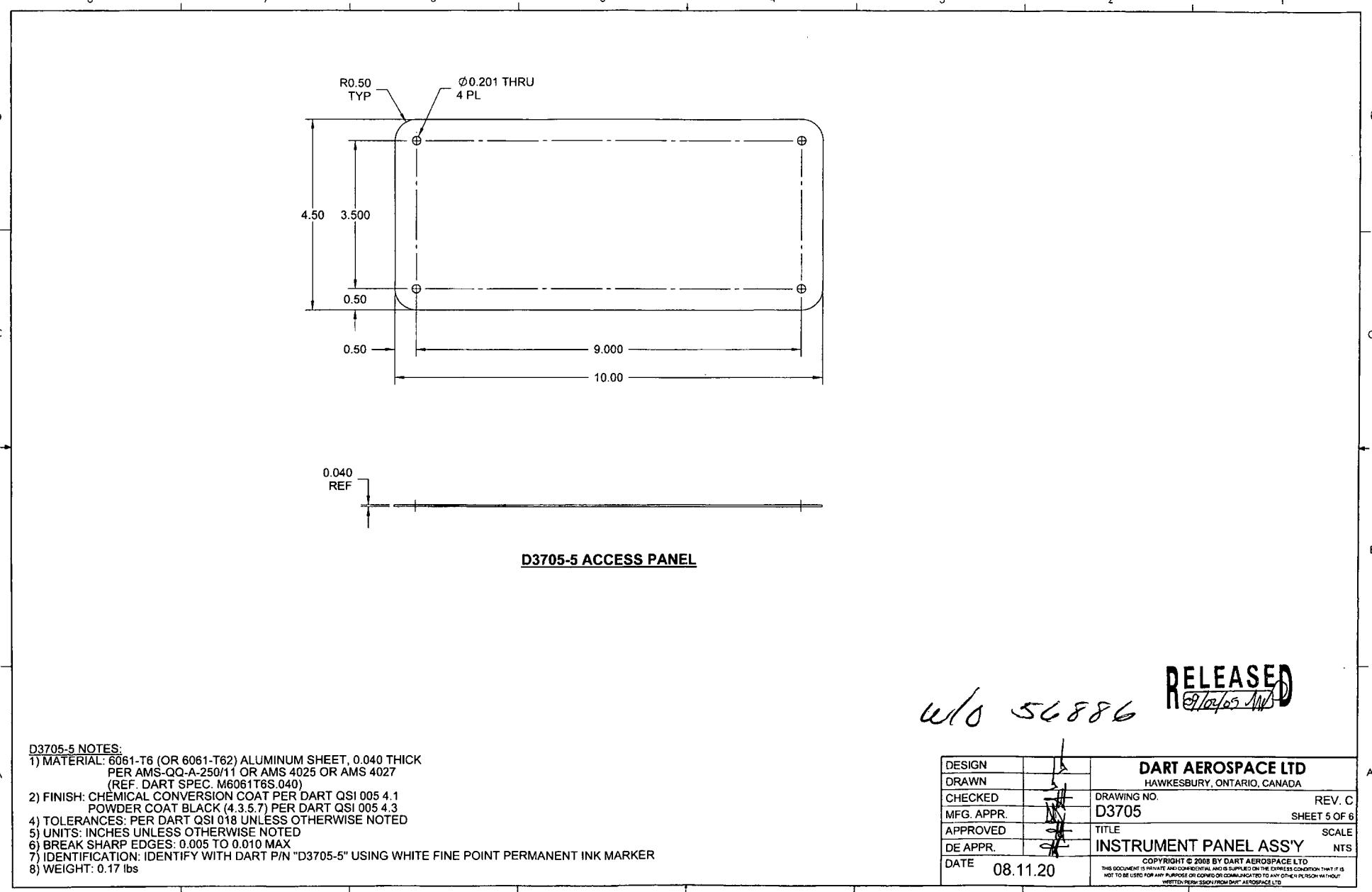
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/ 56886 *RELEASED 9/12/05 M*

DESIGN	<i>15</i>	DART AEROSPACE LTD	
DRAWN	<i>15</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>15</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>15</i>	D3705	SHEET 5 OF 6
APPROVED	<i>15</i>	TITLE	SCALE
DE APPR.	<i>15</i>	INSTRUMENT PANEL ASSY NTS	
DATE	08.11.20		

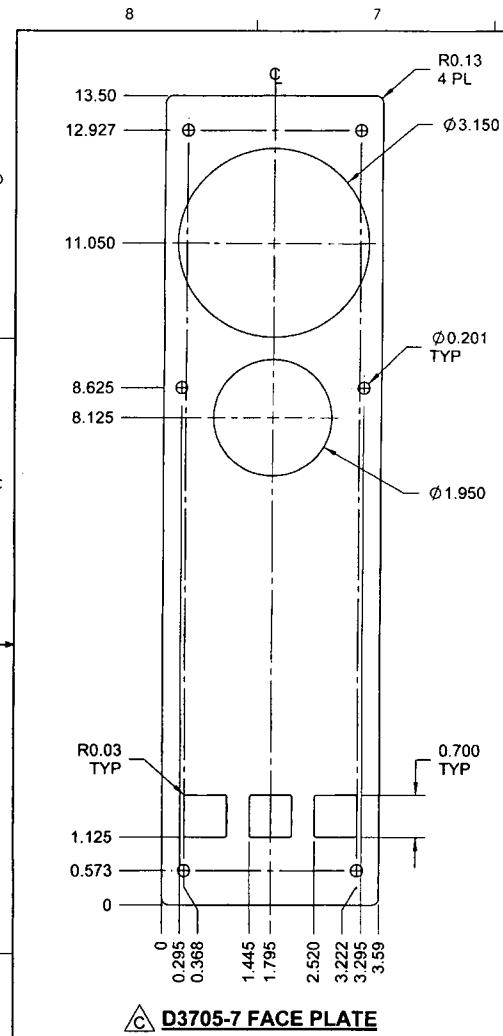
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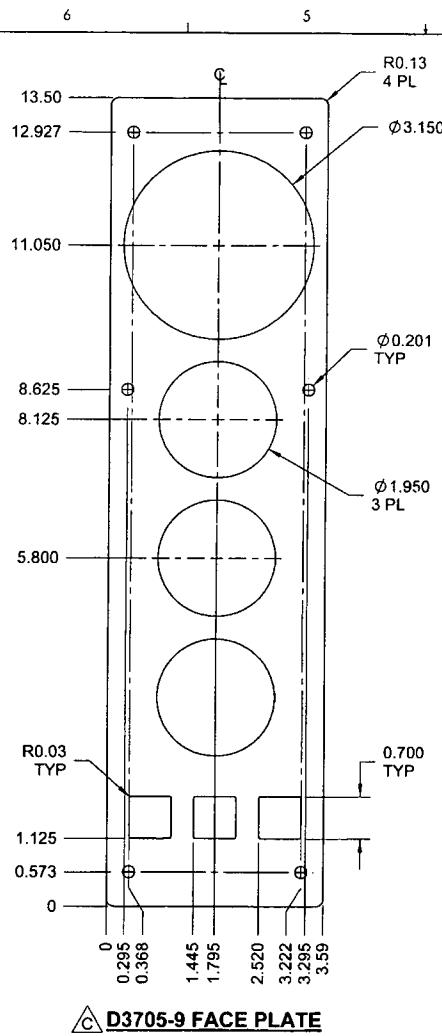
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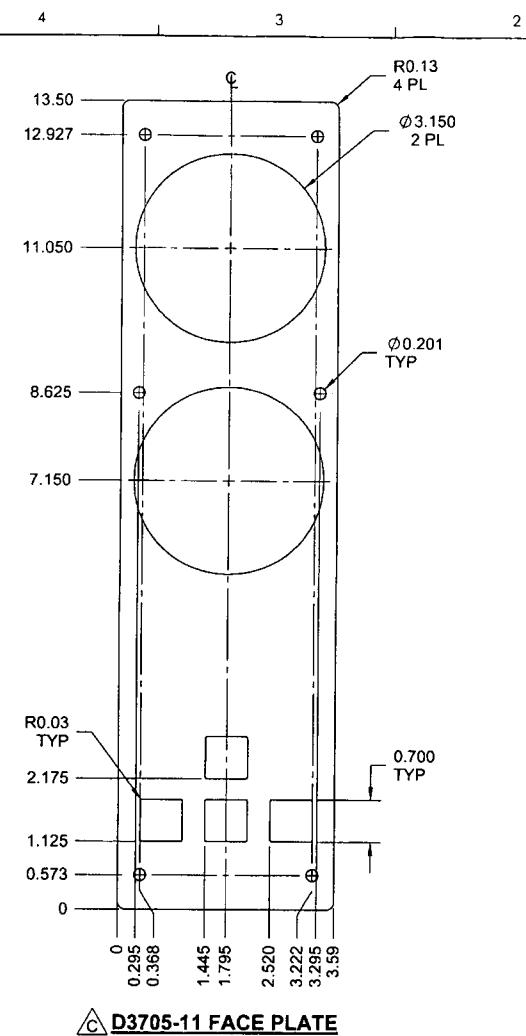
NOTE: Date & initial all entries



C D3705-7 FACE PLATE



C D3705-9 FACE PLATE



C D3705-11 FACE PLATE

D3705-7/9/11 NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER

8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

RELEASED
8/26/03

SIDE VIEW

ART AEROSPACE LTD
AWKESBURY, ONTARIO, CANADA

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3705	SHEET 6 OF 6	
APPROVED		TITLE	SCALE	
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS	
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